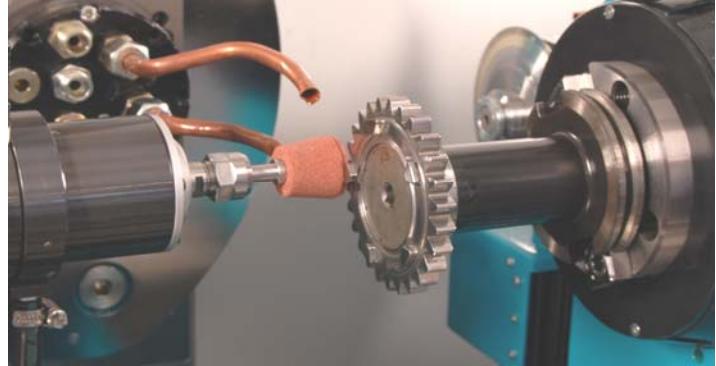


Nocken-Schleifen

A20-200

Bei diesem speziellen Teil handelt es sich um ein Getriebezahnrad eines Rennwagens. Geschliffen werden die polygonalen Positionierungs-Nocken des Zahnrades auf Grund eines dxf. Auch nach dxf wird das Profil der Schleifscheibe abgerichtet. Zum Schleifen wird eine Hochfrequenzspindel benötigt.



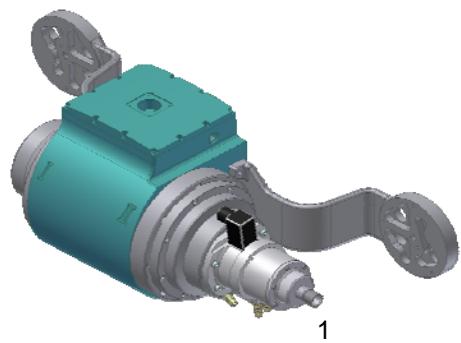
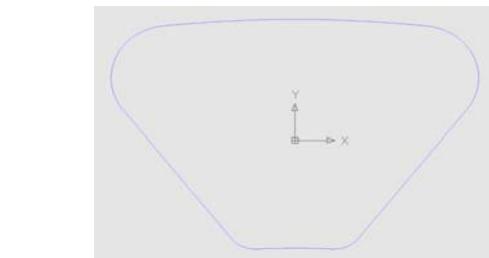
1. Cycletime for Production

Specifications			
Diameter 130 mm, Z5			
Operations	Probe	Dress	Cam
Feed [mm/Min]	2000	150	5
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels			1
Grinding time [s]	20	120	450
Total cycle time	9 Min 50		

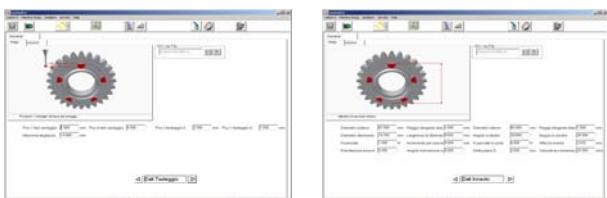
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø36 DXF Conventional



3. Machine and Software Requirements



Machines: 5 axes CNC grinders : NORMA CFG
Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: QUINTO 5, DXQ

Engineer: Di, 01.04.2009

www.schneeberger.ch

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TECHNOLOGY
FOR TOOLING